

ASAP

**Work Order ID 54667**

December 16, 2009 8:33:58 AM

Page 1

Item ID: D3294-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 16/12/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3294

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3294

Dwg Rev: C

Prog Rev: C

\*grain direction on a 45 deg as per dwg\*\*

2-Deburr if necessary

13 10-1-5

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

13 10-1-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54667**

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

27 8/10/05



QC

Memo

0.00

(412)

Quality Control

130

0.00



Brake NC

Memo

0.00

SB 10/10/05

(12)

Brake NC

1-Deburr if necessary  
2-Bend as per Dwg D3294  
(Ensure angle is correct)

140

QC5- Inspect part completeness to step on W/O

0.00

27 8/10/05



QC

Memo

0.00

(412)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 54667**

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Page 3

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Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

BK 10-05-5

12 0



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

M 10-01-05

KTB 0



QC

Memo

0.00

Quality Control

170

0.00



Small Fab

Memo

0.00

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

EB 10/01/06 (R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54667

December 16, 2009 8:33:58 AM

Page 4

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Revision ID:

Stop

Item Name: Bracket

Start Date: 16/12/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/01/06

(X12)

190

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00



Powdercoat

M109091

Memo

0.00

Powder Coating

Start Time: 11:15am  
Oven Temperature: 3209-  
Finish Time: 11:45am

⇒ 11/10/01/06

(X12)

5

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 10-01-06

(12)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**Work Order ID 54667**

December 16, 2009 8:33:58 AM

Page 5

Item ID: D3294-1

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Stop

Item Name: Bracket

Start Date: 16/12/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

Identify as per dwg &amp; Stock Location 212

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

MF 10-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 16, 2009 8:34:31 AM

Page 1

Work Order ID: 54667

Parent Item: D3294-1

Parent Item Name: Bracket


Comments:

Start Date: 16/12/2009

Required Date: 21/12/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080  2024-T3 .080 sheet		Purchased	No			100	sf	169.2618	22.7368			

HB 10-1-5

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
MAT	169.26185	
104921	3	
105411	17	
107460	4.36	
110908	29.52205	
112331	105.8798	
15628	6	
17695	1.5	
18481	2	

12

112331

D3294-5



Doubler

Manufactured No

170 Each 22.0000 12.0000

25/10/01/06

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	22	
47418	8	
50694	14	

6  
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 16, 2009 8:34:31 AM

Page 2

Work Order ID: 54667



Parent Item: D3294-1



Parent Item Name: Bracket

Start Date: 16/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-5

Purchased

No

170

Each

2,487.000

180.0000



Rivet, Universal Head

*EP 10/01/06*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2487

109031

8

111916

2479

180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	54667
<b>Description: Bracket Assembly</b>		<b>Part Number:</b>	D3294-1
<b>Inspection Dwg: D3294 Rev: C</b>		<b>Page 1 of 1</b>	

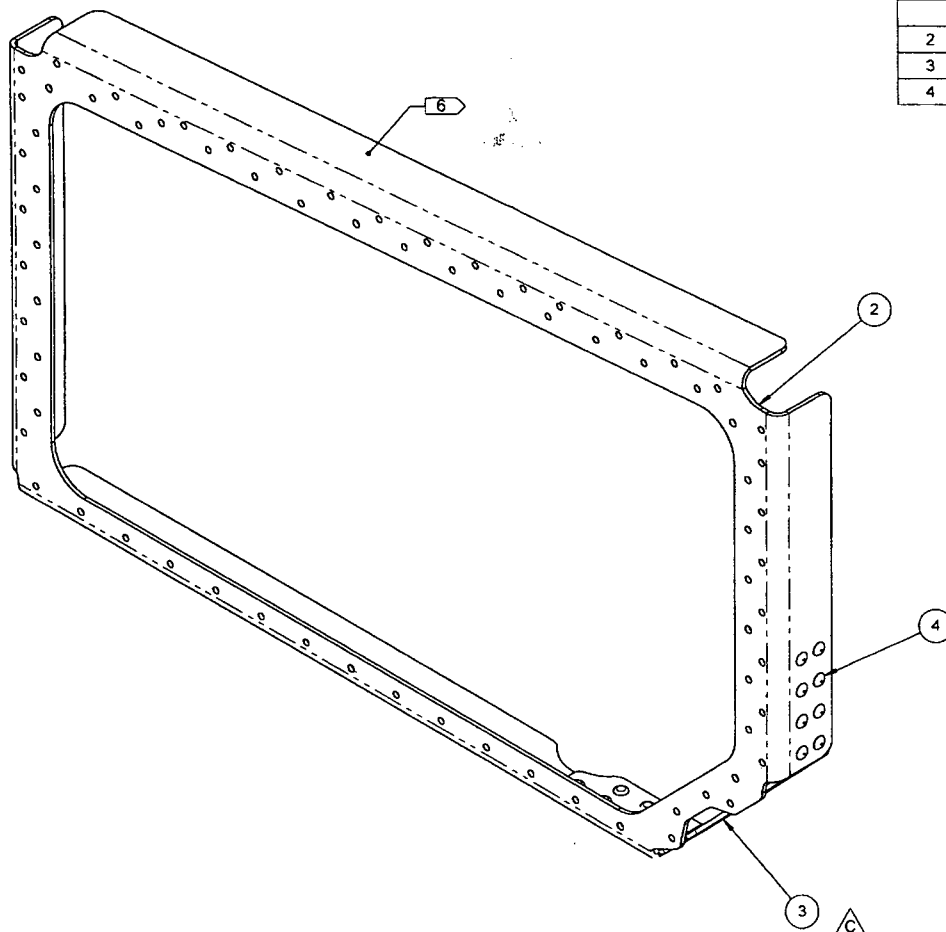
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	✓			
Ø0.141	+0.005/-0.001	.144	✓			
6.708	+/-0.010	6.707	✓			
1.118	+/-0.010	1.117	✓			
5.590	+/-0.010	5.591	✓			
1.118	+/-0.010	1.118	✓			
13.563	+/-0.010	13.563	✓			
1.043	+/-0.010	1.043	✓			
0.625	+/-0.010	.627	✓			
0.325	+/-0.010	.324	✓			
0.300	+/-0.010	.296	✓			
0.400	+/-0.010	.400	✓			
6.000	+/-0.010	5.998	✓			
1.000	+/-0.010	.998	✓			
17.124	+/-0.010	17.125	✓			
16.13	+/-0.030	16.125	✓			
7.27	+/-0.030	7.276	✓			
11.97	+/-0.030	11.958	✓			
8.37	+/-0.030	8.368	✓			
20.05	+/-0.030	20.05	✓			
12.98	+/-0.030	12.98	✓			
14.59	+/-0.030	14.59	✓			
11.66	+/-0.030	11.66	✓			
0.080	+/-0.010	.079	✓			

<b>Measured by:</b>	RB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	10-1-5	<b>Date:</b>	10/01/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET

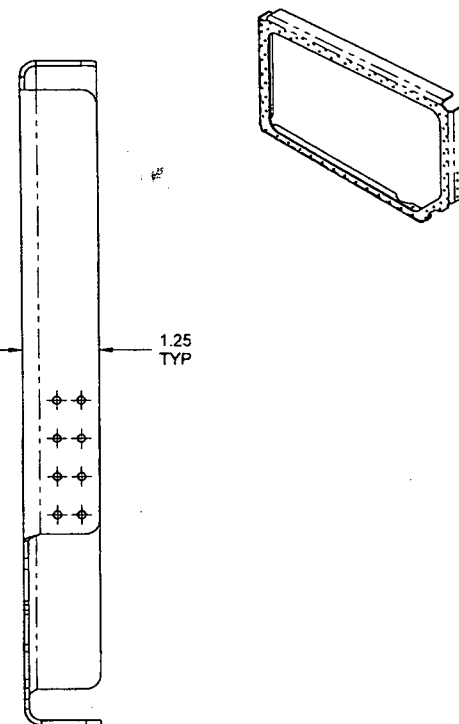
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54667

*B/09-12-16*

**RELEASED**  
*09/07/17*

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE. ZN B4-1. C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3294	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

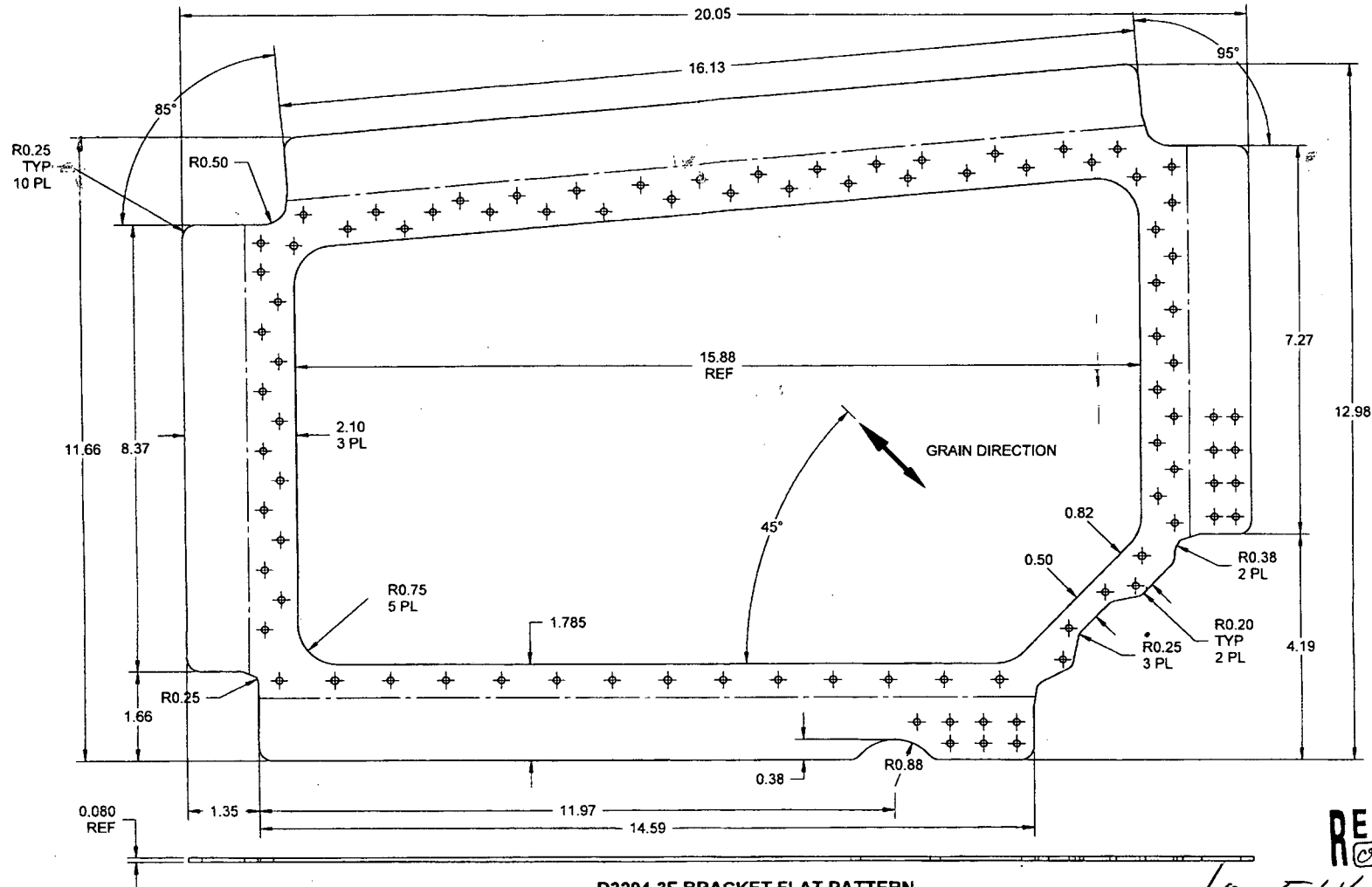




R0.188  
TYP

RELEASE  
09/04/07

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3294	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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**D3294-3F BRACKET FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN	<i>WLO 54667</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. C
CHECKED	<i>[Signature]</i>	D3294	SHEET 3 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	BRACKET	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.03.24		

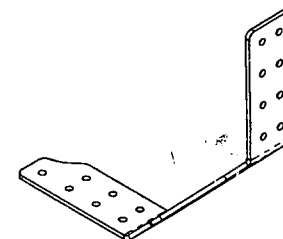
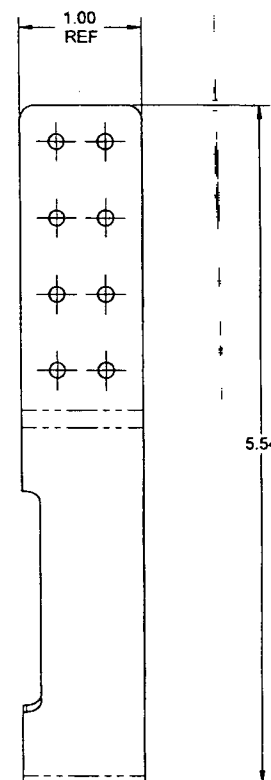
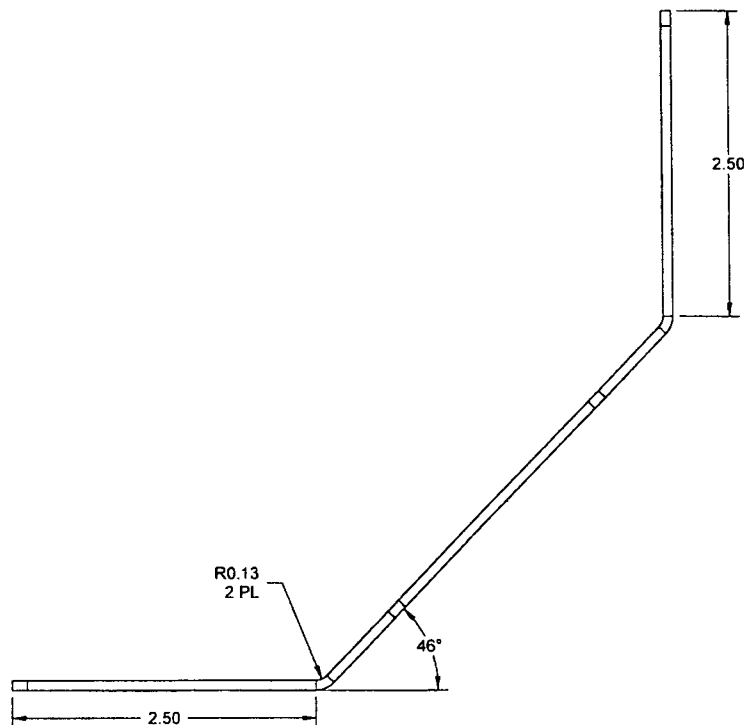
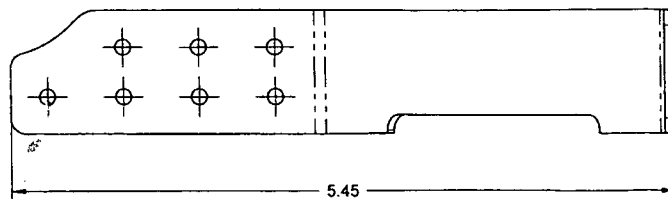
LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

**D3294-3F BRACKET FLAT PATTERN**  
SUPPLEMENTAL

DESIGN	WLO 54667	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3294
MFG. APPR.		REV. C
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE BRACKET
DATE	09.03.24	SCALE NTS

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**RELEASED**  
09/07/07



# NOTES:

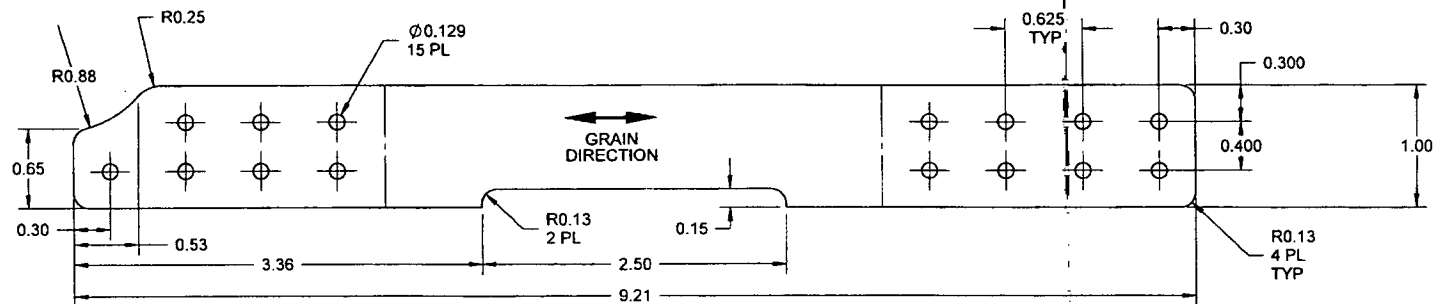
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

**D3294-5 DOUBLER**  
MADE FROM D3294-5F



DESIGN		<b>RELEASED</b> <i>9/10/07</i> <i>W10 54667</i>	
DRAWN			
CHECKED		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.			
APPROVED		DRAWING NO.	REV. C
DE APPR.		D3294	SHEET 5 OF 6
DATE	09.03.24	TITLE	SCALE
		BRACKET	NTS

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**D3294-5F DOUBLER FLAT PATTERN**



**RELEASED**  
9/10/07

W/O 54667

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. <b>D3294</b>	REV. C
MFG. APPR.		TITLE <b>BRACKET</b>	SCALE NTS
APPROVED		<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	09.03.24		